

Work Order ID 114820

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114820

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Item ID: D4743-1

Revision ID:

Item Name: Speaker Grill

Start Date: 14/03/2014 Start Qty: 32.00

32

Required Date: 28/03/2014 Req'd Qty: 32.00

32

Reference:

Approvals: Process Plan: AP Date: 14-03-13

QC: _____ Date: _____

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4743

A

110

110

Waterjet

FLOW CNC Waterjet

6061-080

Memo

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

120

120

QC

Quality Control

Memo

0.00

0.00

0.00

0.00

380Jm14-03-16380Jm14-03-16

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Item ID: D4743-1
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 Start Date: 14/03/2014 Start Qty: 32.00 *32*
 Required Date: 28/03/2014 Req'd Qty: 32.00 *32*
 Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____
 QC: _____ Date: _____

Tooling: _____ Date: _____
 SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140									
Small Fab	Memo	0.00							
Small Fab	C'sink holes as per dwg								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS

27

9-89

14/3/17

38

can

DAS

36

9-89

14/03/17

38x

DAS

27

9-89

14/3/17

38

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Item ID: D4743-1
 Revision ID:
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 Start Date: 14/03/2014 Start Qty: 32.00 ***32***
 Required Date: 28/03/2014 Req'd Qty: 32.00 ***32***
 Reference:

Accept ***N900040100*** Setup Start ***NS1***
 Stop ***NS2***
 Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____
 QC: _____ Date: _____

Tooling: _____ Date: _____
 SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
180									
Powdercoat	Memo	0.00							
Powder Coating	POWDER COAT Start Time: 1:15 Oven Temperature: 320° Finish Time: 2:15								

38 14-3-14
 38 14-3-14
 38 14-3-14
 DAS 34 9-89

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Revision ID:
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Start Date: 14/03/2014 Start Qty: 32.00 *32*
Required Date: 28/03/2014 Req'd Qty: 32.00 *32*
Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Tooling:

Date: _____

SPC (Y/N): _____

Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: MF 4 Memo
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo

Set Up/
Run Hours

0.00

0.00

0.00

0.00

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DAS

27

9-89

14/3/20

38

38

MAR 20 2014

DAS
06
9-89

ML5 1403-21

ML5 14-03-20

Picklist Print

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Parent Item: D4743-1

D4743-1

Parent Item Name: Speaker Grill

Start Date: 14/03/2014

Required Date: 28/03/2014

Start Qty: 32.00

Required Qty: 32.00

Comments: IPP REV:A 12.11.14 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

110

sf

367.3800

0.195

7

M6061T6S 080

**

Jm 14-03-16

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT021

367.38

m126309

161.12

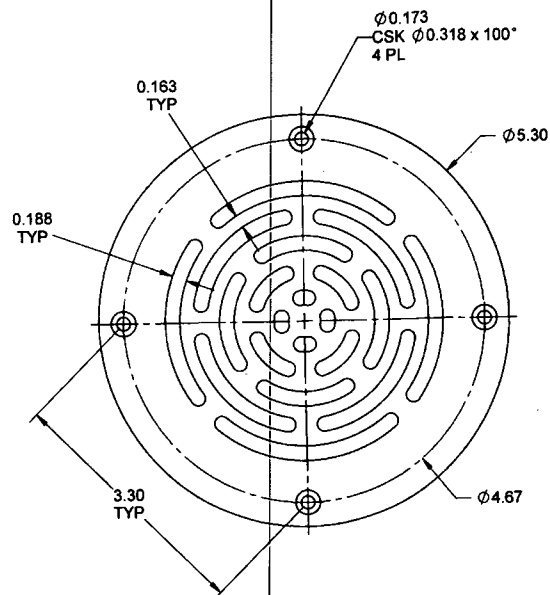
m126350

14.26

m128408

192

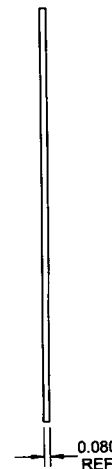
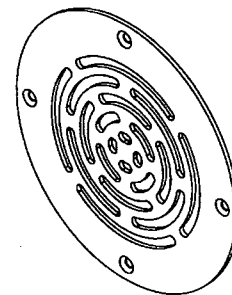
128408.



D4743-1 SPEAKER GRILL

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.13 lbs
- 8) CUT PART PER D4743-1 REV A.DXF



114'820 M
14-03-13
RELEASED
2013-01-30
2013-01-30

A NEW ISSUE		RF 12.11.30	
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4743	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPEAKER GRILL	NTS
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